

Thursday, July 30, 2015 8:09:52 AM

Page 1

Stop ***NR2***

SEP 30 2015

JUL 30 2015

SEP 3 7 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

Work Order ID 135137

135137

Page 2

Thursday, July 30, 2015 8:09:52 AM

Item ID: D350-822-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: PA100 PUREair System for AS350/EC130
 Start Date: 7/30/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/07/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

Consignment Stock

0.00

125

Outsourc10

Memo

0.00

Consignment stock

Issue PO to GL account 50000-25 to LEAVE W/O OPEN UNTIL SOLD

Issue W/O LINE item for Pall for amount sold on sales order S/O _____
 according to sales price see Warran for amount. (if sale price is \$23,000 -
 amount is \$13,400)
 PO can be received immediately and given to finance in order to close work
 order.

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-822-011

Location: BK 001

DAS
02
9-89

OCT 01 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Issued to
RD15-822-01

SA 20151009

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER : _____			

Picklist Print

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Page 1

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.02.20 NEW ISSUE DD VERF:JLM IPP
REV:B 14.06.18 AS PER IIN REV.C DD VERF:JLM IPP REV:C
15.06.03 AS PER IIN REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149D0332J

Purchased

No

Each

2,510.000

58

NAS1149D0332.J

Washer

**

JA

JUL 31 2015

DAS
6
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

650

m132677

650

ST269

1852

m130325

900

m131624

60

m132677

892

58

ST270

-6

m132189

-6

QR10616

Purchased

No

Each

9.0000

1

QR10616

Vortex Tube Repair

**

JA

DAS
02
9-89

Location

Loc Qty

Loc Code

MEZZpall

9

m129631

2

m129913

7

1

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
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					QC / QA Coordinator Approval	
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Picklist Print

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Page 2

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

QB21304 Purchased No

Each 9.0000

QB21304 → 5th RAS-5162
PUREair Panel Assembly

**

1

DAS
6
9-89

Location

Loc Qty

Loc Code

MEZZpall

8

118409

8

ST

1

m129914

1

QB21310 Purchased No

Each 9.0000

QB21310
Transition Duct Assembly

**

1

DAS
6
9-89

Location

Loc Qty

Loc Code

MEZZ2

7

m129914

7

MEZZpall

2

m129631

2

QB21308 Purchased No

Each 9.0000

QB21308
Fod Screen Assembly

**

1

JUL 31 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

MEZZ2

7

m129914

7

MEZZpall

2

m129631

2

LN29985-A05 Purchased No

Each 0.0000

LN29985-A05
Anchor Nut (USE LN29985-AM5)

**

15

133062

SD

DAS
02
9-89

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

LN9038-05018

Purchased

No

Each

560.0000

56

LN9038-05018

Bolt

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

st555

560

M132419

560

56

BS4320-A5

Purchased

No

Each

192.0000

56

BS4320-A5

Washer

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

MEZZpall

192

M129914

192

56

MS20426AD3-3

Purchased

No

Each

4,079.000

40

MS20426AD3-3

RIVET

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST313

4079

M131624

4079

40

650.0401

Purchased

No

Each

31.0000

1

650 0401

PUREair Fairing Assembly

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

MezzPall

31

132155

31

1

D4925-041

Manufactured

No

Each

3.0000

1

D4925-041

Mounting Plate Assembly

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

cck016

3

133813

3

1

Thursday, July 30, 2015 8:09:56 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																									

Picklist Print

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Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

D4931-1 Manufactured No

Each 5.0000

D4931-1

Engine Fitting (for acft models B2 & previous)

DAS
02
9-89

Location

Loc Qty

Loc Code

ST139

5

120906

1

121325

4

**

1
JA

DAS
6
9-89

D4931-3

Manufactured No

Each 15.0000

D4931-3

Engine Fitting (for B3 models)

DAS
02
9-89

Location

Loc Qty

Loc Code

ST139

15

120907

11

121326

4

**

1
JA

DAS
6
9-89

D4931-5

Manufactured No

Each 18.0000

D4931-5

Engine Fitting (for B3e models)

DAS
02
9-89

Location

Loc Qty

Loc Code

ST139

18

120908

13

121327

5

**

1
JA

DAS
6
9-89

D4935-1

Manufactured No

Each 16.0000

D4935-1

Mounting Bracket

DAS
02
9-89

Location

Loc Qty

Loc Code

ST139

16

134472

16

**

6
JA

1111 30 2015

DAS
6
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
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			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Page 5

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

D4943-1

Manufactured No

Each

35.0000

1

D4943-1

Flex Hose

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST220a

19

119750

1

119753

7

119754

8

119755

3

st220b

16

119751

8

119752

8

D4961-041

Manufactured No

Each

9.0000

1

D4961-041

Tube Assembly

DAS
02
9-89

**

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST140

5

134764

5

ST142b

4

134747

4

D4961-043

Manufactured No

Each

3.0000

1

D4961-043

Tube Assembly

DAS
02
9-89

**

JA

JUL 30 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

ST140

3

133899

1

134275

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, July 30, 2015 8:09:57 AM

Page 6

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

D5079-1 Purchased No

Each 8.0000

D5079-1

Placard, EAPS

DAS
02
9-89

**

2
JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST145

8

130339

8

0.0000

**

7

DAS
6
9-89

D5090-041

Manufactured No

Each

D5090-041

Duct Assembly

DAS
02
9-89

**

1

AUG 10 2015

DAS
6
9-89

D5105-1

Manufactured No

Each

D5105-1

Handle

DAS
02
9-89

**

1 2
JA

Location

Loc Qty

Loc Code

ST147

14

121244

14

5.0000

**

2

DAS
6
9-89

D5110-1

Manufactured No

Each

D5110-1

Swivel Nut Fitting

DAS
02
9-89

Location

Loc Qty

Loc Code

ST148

5

121874

5

14.0000

**

1

JUL 30 2015

DAS
6
9-89

D5179-1

Manufactured No

Each

D5179-1

Doubler

DAS
02
9-89

Location

Loc Qty

Loc Code

ST228A

14

134370

4

10

2

Thursday, July 30, 2015 8:09:57 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval
Description Work Order Deviation				Disposition		Completed By
						Lead hand / Supervisor Approval Verification
						QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____

Picklist Print

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Page 7

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

D5179-3 Manufactured No

Each 14.0000

D5179-3

Doubler

DAS
02
9-89

**

2
JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST228A

14

134502

4

134760

10

2

D5194-1

Manufactured No

Each 14.0000

D5194-1

Doubler

DAS
02
9-89

**

2
JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST228A

14

134480

2

134761

12

2

D5208-041

Manufactured No

Each 6.0000

D5208-041

Blanking Plate Assembly

DAS
02
9-89

**

3
JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST152

6

134328

6

3

8411999090

Purchased No

Each 10.0000

8411999090

Gasket - P/N 9752100180

DAS
02
9-89

**

1
JA

JUL 30 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

ST564

10

m132879

10

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER :																																																																							

Picklist Print

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Page 8

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

9752018044

Purchased

No

Each

9.0000

9752018044

Gasket (for B3 models)

DAS
02
9-89

**

1

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST564

9

m129550

9

1

9945000120

Purchased

No

Each

9.0000

9945000120

Gasket (for B3e models)

DAS
02
9-89

**

1

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST564

9

m129550

9

1

23350CA050

Purchased

No

Each

69.0000

23350CA050

WASHER

DAS
02
9-89

**

2

JA

DAS
6
9-89

Location

Loc Qty

Loc Code

ST568

69

m129609

69

2

AN821-12J

Purchased

No

Each

21.0000

AN821-12J

Elbow (or AN821-12K or 12S)

DAS
02
9-89

**

2

JA

JUL 30 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK003

20

m129760

10

m132479

10

ST324

1

m129566

1

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

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Required Qty: 1.00

13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, July 30, 2015 8:09:57 AM

Page 10

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

LN9348-05

Purchased

No

Each

220.0000

26

LN9348-05

**

JA

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

st555

220

m132435

46

26

m132519

174

MS20470AD3-4

Purchased

No

Each

1,937.000

18

MS20470AD3-4

**

JA

Rivet, Universal Head

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

782

111477

782

ST311

1155

11477

1155

18

MS21919WCH12

Purchased

No

Each

9.0000

1

MS21919WCH12

**

JA

Clamp

DAS
02
9-89
9-89

Location

Loc Qty

Loc Code

ST295

9

m130358

9

MS9592-138

Purchased

No

Each

28.0000

1

MS9592-138

**

JA

Bracket

DAS
02
9-89

Location

Loc Qty

Loc Code

ST272

28

m132479

28

1

Thursday, July 30, 2015 8:09:58 AM

Shop Packet Print

Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 11

Work Order ID: 135137

135137

Parent Item: D350-822-011

D350-822-011

Parent Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Required Date: 8/07/15

Start Qty: 1.00

Required Qty: 1.00

NAS43DD3-64

Purchased

No

Each

13.0000

1

NAS43DD3-64

JA

JUL 30 2015

Spacer

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

13

m132461

13

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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		OTHER :																																																																					

Work Order ID 135137

Thursday, July 30, 2015 8:09:52 AM

135137

Page 1

Item ID: D350-822-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: PA100 PUREair System for AS350/EC130

Start Date: 7/30/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/07/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: 15.7.30

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Draw Nbr	Revision Nbr	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
11N-D350-822	D	JA							

100
100
DC
Doc.Control -USB or Paperwork

DOCUMENT CONTROL
Memo
Photocopy bluefile & type labels per PPP D350-822-011 CHG002

SH 2015 / 7/30

110
110
Packaging
Packaging

Pick Kit
Memo

0.00
0.00

① JA JUL 30 2015

120
120
QC
Quality Control

QC4- 100% Inspect kits for completeness
Memo

0.00
0.00

REFERENCE ONLY

DAS
02
9-89

5.0 PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-011		
X	D350-822-011	PA100 PUREAIR SYSTEM
1	QR10616	TUBE REPAIR KIT
1	QB21304	PUREAIR PANEL ASSY
1	QB21310	TRANSITION DUCT ASSY
1	QB21308	FOD SCREEN ASSY
15	LN29985-A05	ANCHOR NUT
56	LN9038-05018	BOLT
56	BS4320-A5	WASHER
40	MS20426AD3-3	RIVET
1	650.0401	PUREAIR FAIRING ASSY
1	D4925-041	MOUNTING PLATE ASSY
1	D4931-1	ENGINE FITTING*
1	D4931-3	ENGINE FITTING*
1	D4931-5	ENGINE FITTING*
6	D4935-1	MOUNTING BRACKET
1	D4943-1	FLEX HOSE
1	D4961-041	TUBE ASSEMBLY
1	D4961-043	TUBE ASSEMBLY
2	D5079-1	PLACARD
1	D5090-041	DUCT ASSEMBLY
2	D5105-1	HANDLE
1	D5110-1	SWIVEL NUT FITTING
2	D5179-1	DOUBLER
2	D5179-3	DOUBLER
2	D5194-1	DOUBLER
3	D5208-041	BLANKING PLATE ASSY
1	8411999090	GASKET*
1	9752018044	GASKET*
1	9945000120	GASKET*
2	23350CA050	LOCKING TAB
2	AN821-12J	ELBOW (OR AN821-12K OR AN821-12S)
1	AN929-12J	CAP
58	BS4320-A5	WASHER (OR NAS1149D0332J)
2	EN3686-050016	SCREW
32	LN9038-05012	BOLT
1	LN9038-05040	BOLT
26	LN9348-05	NUT
18	MS20470AD3-4	RIVET
1	MS21919WHG12	CLAMP
1	MS9592-138	BRACKET
1	NAS43DD3-64	SPACER

* USE APPROPRIATE FITTING/GASKET BASED ON ENGINE INSTALLATION

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-822 REV. C/D

REF. TCCA STC: SH14-14

REF. ANAC STC: 2014S07-11

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO PROVIDE AN UPGRADE KIT SO THAT CUSTOMERS WHO HAVE RECEIVED D350-822-011 @ CHG 001 (REF IIN-D350-822 REV. C) CAN UPGRADE THEIR KIT TO D350-822-011 @ CHG 002 (REF IIN-D350-822 REV. D) AND INSTALL THE KIT PER IIN-D350-822 REV. D.

2.0 CHANGE

THE DSI 9723-011 UPGRADE KIT IS DETAILED AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9723-011	PA100 PUREAIR SYSTEM UPGRADE KIT
1	650.0401	PUREAIR FAIRING ASSY *
1	AN821-12J	ELBOW
58	BS4320-A5	WASHER (OR NAS1149D0332J)
1	D4925-041	MOUNTING PLATE ASSY *
1	D4961-043	TUBE ASSEMBLY
2	D5179-1	DOUBLER
2	D5179-3	DOUBLER
2	D5194-1	DOUBLER
3	D5208-041	BLANKING PLATE ASSY
2	EN3686-050016	SCREW
15	LN29985-A05	ANCHOR NUT
32	LN9038-05012	BOLT
56	LN9038-05018	BOLT
1	LN9038-05040	BOLT
26	LN9348-05	NUT
40	MS20426AD3-3	RIVET
1	MS9592-138	BRACKET
1	NAS43DD3-64	SPACER

* UPGRADE TO METRIC HARDWARE

3.0 WEIGHT AND BALANCE

This DSI has a negligible effect on Weight and Balance.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.05.29
CERT. NO.: SH14-14
ISSUE NO.: 1

A	NEW ISSUE	AK	15.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9723	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.		PA100 UPGRADE KIT	NTS
DATE	15.05.29	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	